INCORPORATES
THE FOLLOWING BUR. OF AERO. CHANGES
MODEL PBY-1-CHANGE #75, #83
MODEL PBY-2 CHANGE #27, #42
MODEL PBY-3 CHANGE #7, #18

SUPPLIES & EQUIPMENT CLASSIFICATION

LET	ALTERATION	DATE	BY
L	TRACED UP TO DATE		
M	-6, -7, WERE 24ST		
N	ON -18 4½ WAS 3⅝ & 2¼ WAS 4⅜		
	ADDED 4 ADDITIONAL RIVETS		
	-18 WAS .051 NOW .031 SHEET		
P	28B1391-2 WAS 28B1391	6-8-39	
R	ADDED -22 WEB & -23 & -24 FILLERS		
S	REMOVED -24 FILLER		
T	28B073 WAS 28B077		
	AN442-D6 WAS AN442-D4		
	ADDED 28B075	11-12-40	
U	CHGD. K1559-24ST TO K1559-24SO FOR -8 & -21. NO WT. CHG.	1-2-41	

SPLICE

SECTION A-A

SECTION B-B

SECTION C-C

SECTION E-E

STRINGER

VIEW D-D

FORWARD

KEEL LINE

BEVEL IS CONSTANT BETWEEN THESE POINTS

ALL RIVETS AN442-D6

FILLER 2⅝ x ¾ x .051 AN442-D6

CLIP 28B073 AN442-D6

CLIP 28B070

CLIP 28B075 AN442-D6

.035 WEB

.051 SHEET

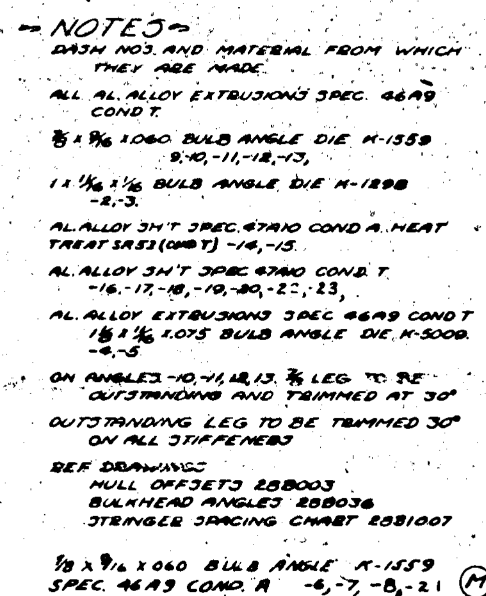
.030 SHEET

BEND ANGLE SEE SECTION L-L DWG 28B528

OMIT THIS RIVET ON PORT SIDE

SEE SECTION C-C

FINISH:- 2P-2 ON PBY-1 & PBY-1, 2-P-2 ON PBY-2 & FUTURE


NOTES
DASH NOS. AND MATERIAL FROM WHICH THEY ARE MADE.
ALL AL. ALLOY EXTRUSIONS SPEC. 46A9 COND T.
⅝ x 9/16 x .060 BULB ANGLE DIE K-1559 -9, -10, -11, -12, -13,
1 x 11/16 x 1/16 BULB ANGLE DIE K-1298 -2, -3.
AL. ALLOY SH'T SPEC. 47A10 COND A. HEAT TREAT SR53 (COND T) -14, -15.
AL. ALLOY SH'T SPEC 47A10 COND. T -16, -17, -18, -19, -20, -22, -23,
AL. ALLOY EXTRUSIONS SPEC 46A9 COND T 1⅝ x 1⅛ x .075 BULB ANGLE DIE K-5009. -4, -5
ON ANGLES -10, -11, 12, 13. ⅝ LEG TO BE OUTSTANDING AND TRIMMED AT 30°
OUTSTANDING LEG TO BE TRIMMED 30° ON ALL STIFFENERS
REF DRAWINGS
HULL OFFSETS 28B003
BULKHEAD ANGLES 28B036
STRINGER SPACING CHART 28B1007
⅛ x 9/16 x .060 BULB ANGLE K-1559 SPEC. 46A9 COND. A -6, -7, -8, -21 (M) (U)

FINISH CODE	
Z	ANODIC TREAT
P	P-27 PRIMER
AP	ALUMINIZED PRIMER
C	CADMIUM PLATE

PART NO.					
28B073					2
28B075					2
-23		2	2	2	2
28B680-22		2	2	2	2
AN340-D6	4	2	2	2	2
AN505-D6-8	4	2	2	2	2
AN442-D6					
AN442-D5					
AN442-D4					
85761-K6-35	2	2	2	2	2
28B1391-2	2	2	2	2	2
28B212	2	2	2	2	2
28B077	4	4	4	4	
28B070	2	2	2	2	2
28B680-21	1	1	1	1	
-20	2	2	2	2	2
-19	2	2	2	2	2
-18	2	2	2	2	2
-17	2	2	2	2	2
-16	2	2	2	2	2
-15	1	1	1	1	1
-14	1	1	1	1	1
-13	1	1	1	1	1
-12	1	1	1	1	1
-11	1	1	1	1	1
-10	1	1	1	1	1
-9	1	1	1	1	1
-8	1	1	1	1	1
-7	1	1	1	1	1
-6	1	1	1	1	1
-5	1	1	1	1	1
-4	1	1	1	1	1
-3	1	1	1	1	1
28B680-2	1	1	1	1	1

SEE RELEASE SHEET FOR ADDITIONAL REQM'TS

MODEL	NEXT ASSY.	REQ.
28 SME	28B1000	1
PBY-5		1
PBY-4		1
PBY-3		1
PBY-2		1
PM-1	28B1000	1
XPBY-1	28B001	1

BELTFRAME - STA. 6.B
PORT SIDE - LOOKING FORWARD

UNLESS OTHERWISE SPECIFIED
ALL RIVETS ARE AN442-D5
5/32 DRILL FOR AN442-D5 RIVETS
3/16 DRILL FOR AN442-D6 RIVETS

ALL AL. ALLOY SHEET 24ST SPEC. 47A10 (CONDITION T) ALLOY 24ST EXCEPT AS NOTED
ALL AL. ALLOY EXTRUSIONS SPEC. 46A9 (CONDITION T) ALLOY 24ST EXCEPT AS NOTED
HEAT TREAT ALL CONDITION A. MATERIAL PER SPEC. 5863 (COND. T)
RIVETS AL. ALLOY EXCEPT AS NOTED

REPLACES
REPLACED BY
LIMIT ON DIMENSIONS UNLESS OTHERWISE SPECIFIED ± 1/32
[redacted]
APPROVED 5-24-37
SCALE
NAVY NOTED — NOTED — NOTED — NOTED
MATERIAL 24S — SPEC. — HEAT TREAT — FINISH
CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.
NAME BELTFRAME-HULL-STA 6B
J 28B680

H 66